

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021909**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 066261 perform repair welding by Shielded Metal Arc Welding (SMAW), on Edge panel I- rib to floor beam weld of OBG Segment 13AW. Weld joint is identified as SEG3013AA-044. ZPMC Quality Control (QC) Inspector identified as Liu Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair and Critical welding repair report B-CWR2796.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on deck panel DP3122A to deck panel DP3123A splice weld of OBG Segment 13AW. Weld joint is identified as SEG3013-006. ZPMC Quality Control (QC) Inspector identified as Liu Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-223(2)1T-ESAB-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on deck panel DP3119A to deck panel DP3120A splice weld of OBG Segment

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13AW. Weld joint is identified as SEG3013-009. ZPMC Quality Control (QC) Inspector identified as Liu Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-223(2)1T-ESAB-1.

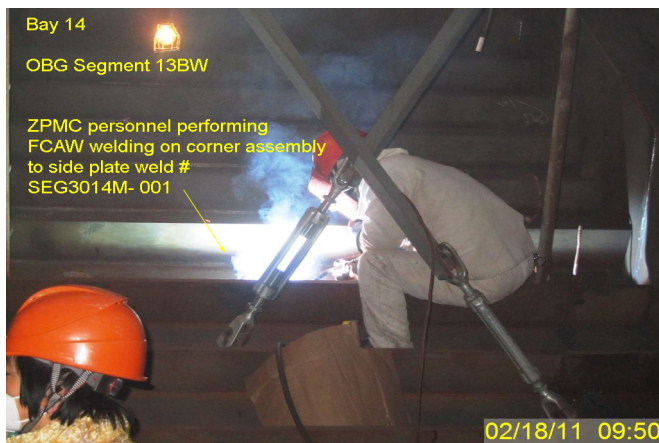
This QA Inspector observed ZPMC qualified welding personnel identified as 066443 perform repair welding by Shielded Metal Arc Welding (SMAW), on K-Plate to Side panel weld of OBG Segment 13BW. Weld joint is identified as SEG3014S-058. ZPMC Quality Control (QC) Inspector identified as Liu Feng was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and welding repair report B-WR20254.

This QA Inspector observed ZPMC qualified welding personnel identified as 067520 perform welding by Shielded Metal Arc Welding (SMAW), on deck panel of OBG Segment 14W. Weld joint is identified as DP3172-019. ABF Quality Assurance (QA) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QA appeared to be in general compliance with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 201583 perform welding by Flux Cored Arc Welding (FCAW), on Corner assembly to Side plate weld of OBG Segment 13BW. Weld joint is identified as SEG3014M-001. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform repair welding by Shielded Metal Arc Welding (SMAW), on vertical shear plate to Bottom panel weld of OBG Segment 14W. Weld joint is identified as SEG3020BB-019. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2752 Rev-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
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Reviewed By:	Clifford, William	QA Reviewer
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